

Work Order ID 77554

Tuesday, December 13, 2011 2:39:10 PM

77554

Page 1

Item ID: D3912-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Block
 Start Date: 12/13/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: / Date: 11-12-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 2.50" LONG								

110		0.00							
110									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA870 AND DWG								
	FOLIO REV: <u>11</u>								
	DWG REV: <u>73</u>								
	DEBURR								

12 03-08 (10)

29 12-3-10 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	29	12.3.10		10	φ		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/03/12		10	φ		
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>S70</u> Memo	0.00 0.00							

(10X) SP 12-03-12.

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Work Order ID 77554***77554***

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Item ID: D3912-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eyebolt Block

Start Date: 12/13/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/5/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

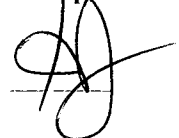
170

QC

Memo

0.00

Quality Control

12/13/12 

12-03-12

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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 13, 2011 2:39:14 PM

Page 1

Work Order ID: 77554

77554

Parent Item: D3912-3

D3912-3

Parent Item Name: Eyebolt Block

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B1.000X1.000

Purchased

No

100

f

10.6820

0.208

2.189474

M303B1 000X1 000

120 602

**

12-03-08

303 BAR 1" X 1"

Location

Loc Qty

Loc Code

MAT050

10.682

118106

10.682

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

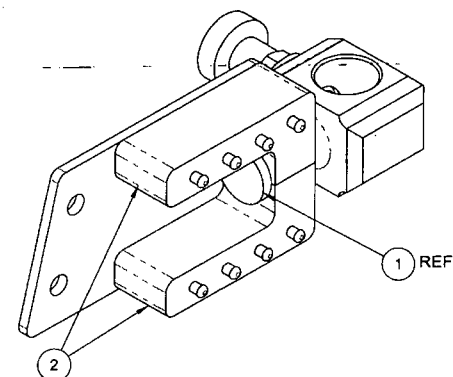
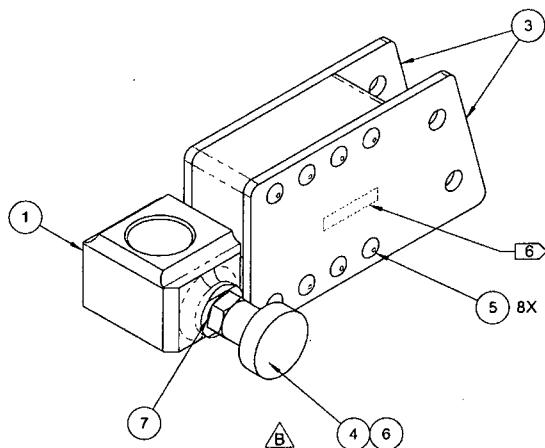
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77554

R112-13



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>	DRAWING NO.	REV. B
CHECKED	<i>JP</i>	D3912	SHEET 1 OF 3
MFG. APPR.	<i>JP</i>	TITLE	SCALE
APPROVED	<i>JP</i>	EYEBOLT RECEIVER ASSY	NTS
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DATE	10.06.28		

Dart Aerospace Ltd

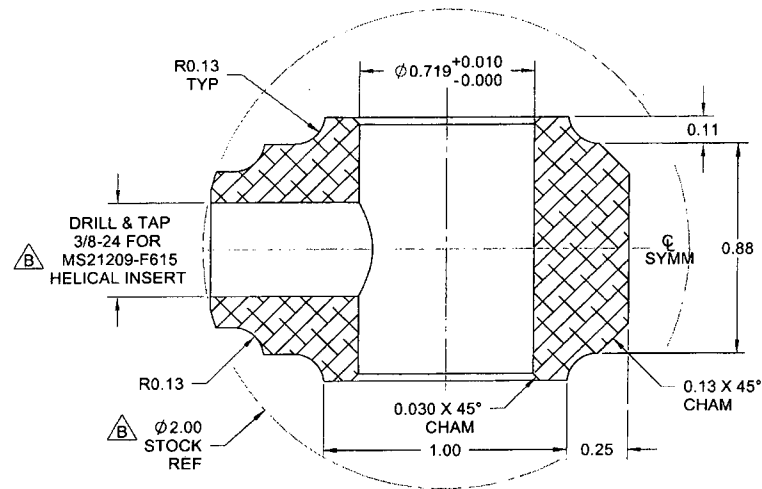
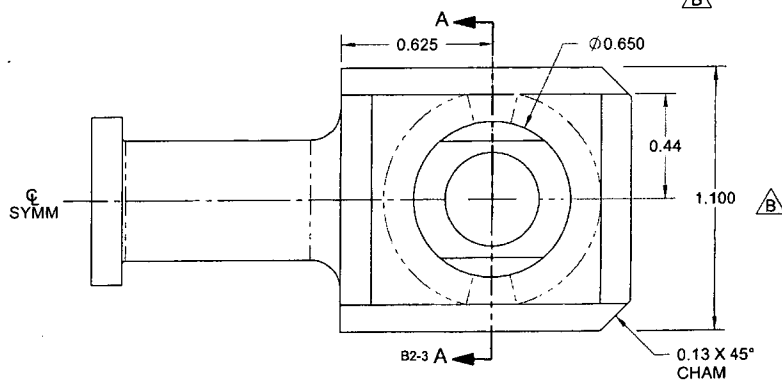
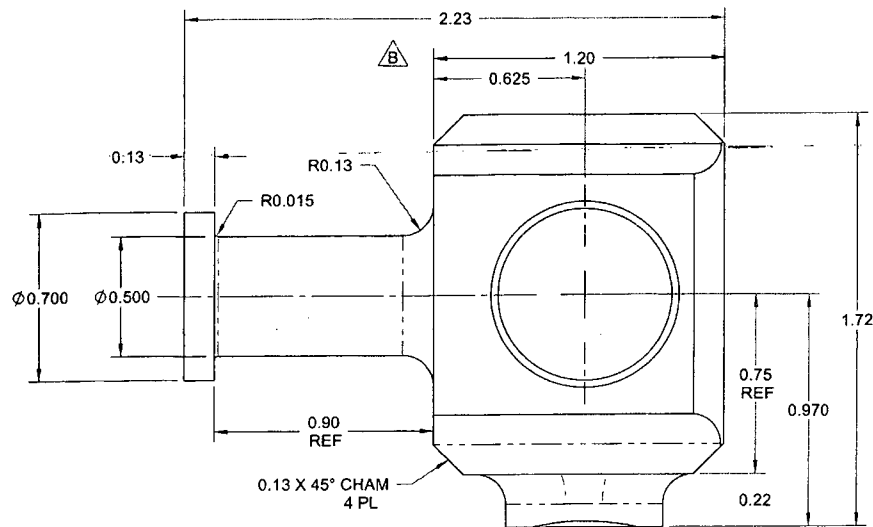
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SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT: 0.45 lbs

77554

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

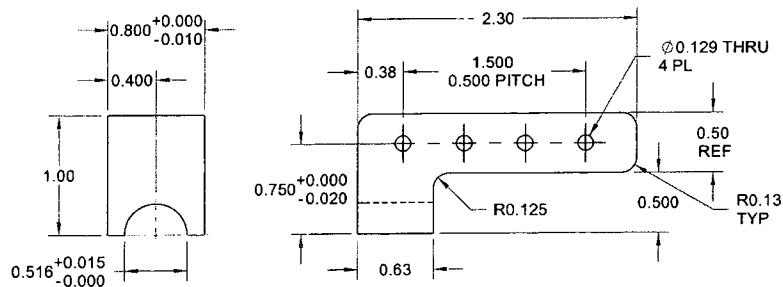
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

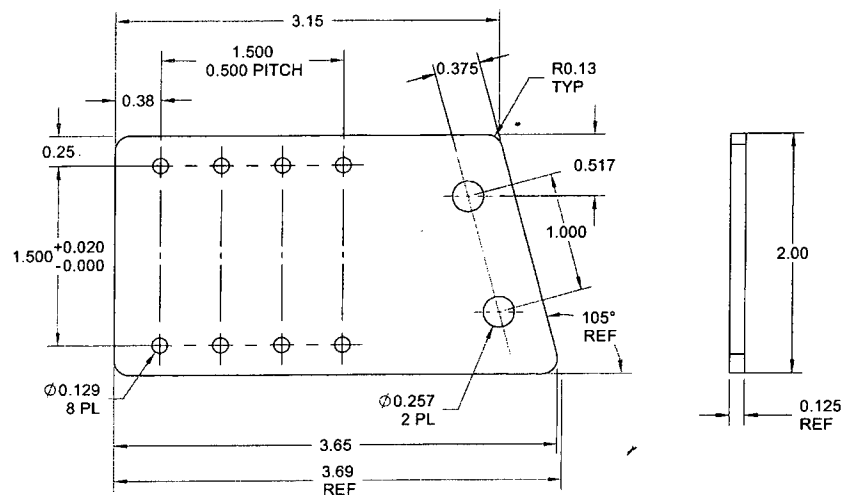
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NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

77554

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	SH	D3912	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	EYEBOLT RECEIVER ASSY	
DATE	10.06.28	NTS	

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